

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005515**Date Inspected:** 08-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As listed below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Luis Hutchins, was present during the times noted above for observations relative to the work being performed.

Inprogress welding:

SAW welding of weld joint ND1-A476-77M-1- 71, 1 and 9. Welder is identified as 042195. ZPMC QC is identified as Yun Dong Ping. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

SAW welding of weld joint ND1-A476-65M-1- 4 and 9. Welder is identified as 042195. ZPMC QC is identified as Yun Dong Ping. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

SAW welding of weld joint ND1-A476-53M-1-11. Welder is identified as 042195. ZPMC QC is identified as Yun Dong Ping. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

FCAW welding of weld joint NSD1-SA166 E/F- 24. Welder is identified as 053870. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS #B-T-2231-TC-U5-F.

FCAW welding of weld joint NSD1-SA166 D/F- 17, 18, and 20. Welder is identified as 057194. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

#B-T-2231-TC-U5-F.

FCAW welding of weld joint WSD1-SA384 A/D- 8, 9, 12 and 13. Welders are identified as 049220, 046706, 040713 and 040775. ZPMC QC is identified as Xiao Yun. The welding variables recorded by QC appeared to comply with the WPS #B-T-2332-TC-P5-F.

FCAW welding of weld joint WSD1-SA225 A/H- 15. Welder is identified as 066283. ZPMC QC is identified as Li Le. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P4-F.

FCAW welding of weld joint WSD1-SA39 A/K- 5 and 3. Welders are identified as 066477, 068917 and 062782. ZPMC QC is identified as Li Le. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P4-F.

FCAW welding of weld joint WSD1-SA39 B/K- 6 and 3. Welders are identified as 066155 and 068753. ZPMC QC is identified as Li Le. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P4-F.

FCAW welding of weld joint WSD1-SA39 A/K- 7 and 10. Welders are identified as 068919, 066164 and 066328. ZPMC QC is identified as Li Le. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P4-F.

FCAW welding of weld joint WD1-A467-47.6M-4-10. Welder is identified as 040252. ZPMC QC is identified as Wu Ming Kai. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3-C-S-1.

Ultrasonic Inspection:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The members are identified in that report.

Magnetic Particle Inspection:

This QA inspector performed MT of approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The members are identified in that report.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations held during the course of inspection.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

for your project.

Inspected By:	Hutchins,Luis	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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